

# Work Order ID 81316

March-12-12 4:47:01 PM

**\*81316\***

Page 1

Item ID: D2221 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 350 Basket Base  
 Start Date: 12/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 26/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								

100 0.00

**\*100\***

Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
 3- tack weld mesh on basket as per dwg D2221  
 A/R ER316 S.S. Rod Batch: ln118366

\*\*\*PLEASE NOTE\*\*\*

IF MAKING -041A OR -043A :  
 DRILL HOLES FOR GAS SPRING  
 IN D3825-041 AS PER  
 DSI 9473

*pl 12.03.16 1x*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo

0.00

*BE*  
*12.03.19 1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*81316\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/03/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 26/03/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

125 Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

## Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
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**\*81316\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/03/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 26/03/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:**      **Date:**      **Tooling:**      **Date:**

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

## Insp. Stamp

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

## Memo

0.00

## Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 7h55 460°F m120 222

OVEN TEMPERATURE: 400° F

FINISH TIME: 8h25

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

### QC3- Inspect Part Finish

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
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 Revision ID: Stop **\*NS2\***  
 Item Name: 350 Basket Base  
 Start Date: 12/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 26/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <i>GA</i>	0.00							
<b>*150*</b>									
Packaging	Memo <i>w/o 81302</i>	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*12/03/23*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 81316

\*81316\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/ILM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	5.0000	1	1			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				80163		5							
D2221-5 *D2221-5* Rib		Manufactured	No			100	Each	8.0000	2	2			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		8							
				67117		2							
				78637		6							
D2221-7 *D2221-7* Rib		Manufactured	No			100	Each	1.0000	1	1			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		1							
				73203		1							

Pl 12.03.16

①  
2

Pl 12.03.16

②  
1

Pl 12.03.16

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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\*81316\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

10.0000

2

2

\*D2232-3\*

Basket Hinge

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA005

10

75581

2

78903

8

D2235-1

Manufactured No

100

Each

19.0000

2

\*D2235-1\*

Basket Rib

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA

5

78636

5

WA005

14

66895

4

79153

10

D2581

Manufactured No

100

Each

33.0000

2

\*D2581\*

Mounting Bracket

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA005

33

69739

1

70766

2

77045

3

77523

27

D3442-1

Manufactured No

100

Each

5.0000

2

\*D3442-1\*

Shim

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA005

5

71783

5

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 81316

**\*81316\***

Parent Item: D2221

**\*D2221\***

Parent Item Name: 350 Basket Base

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100

Each

4.0000

2

2

**\*D3825-041\***

Rib Assembly (Basket End)

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA

4

*78638*

4

*5*

100

Each

2.0000

2

2

D3826-041

Manufactured No

**\*D3826-041\***

Rib / Gusset Assembly

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA005

2

*77676*

2

*2*

100

Each

4.0000

1

1

D3827-041

Manufactured No

**\*D3827-041\***

Rib Assembly (Inboard)

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA006

4

*72729*

1

*77546*

3

*1*

100

Each

1.0000

1

1

D3832-1

Manufactured No

**\*D3832-1\***

Mesh (Base)

\*\*

*Pl 12.03.16*

Location

Loc Qty

Loc Code

WA006

1

*78635*

1

*1*

~~37252~~ → *1*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 81316

\*81316\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

9.0000

2

2

\*D3833-1\*

Mesh (Base End Face)

\*\*

*Pl 12-03-12*

Location

Loc Qty

Loc Code

WA

7

77521

7

WA035

2

79335

2

*2*

March-12-12 4:47:05 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

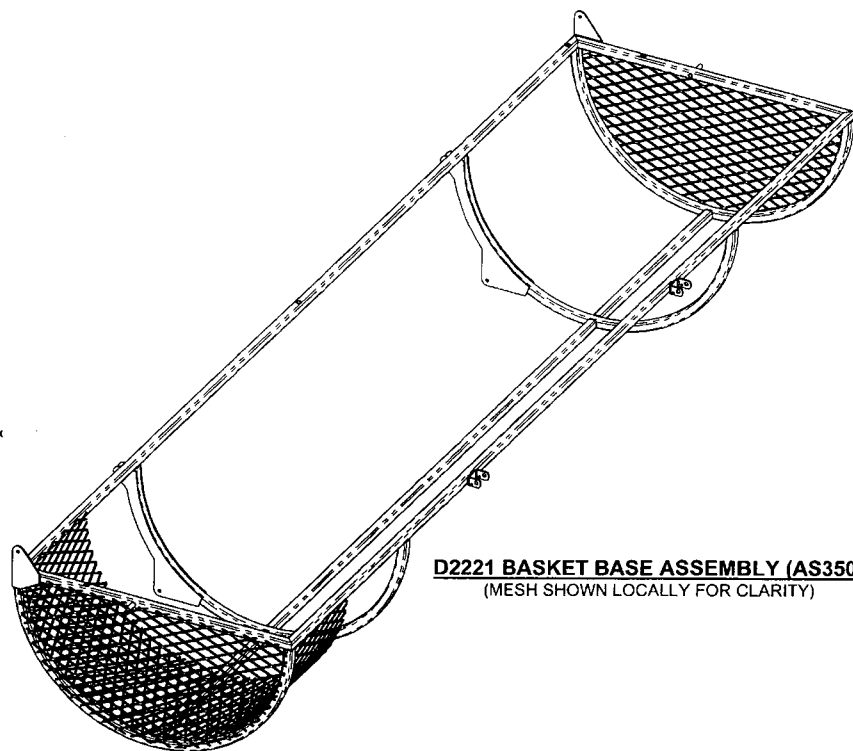
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 81316 MLJ  
12/03/13

RECEIVED  
08/11/13

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	JSS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Technical drawing of a rib assembly, showing two views: a side elevation and a cross-section.

**Side Elevation View:**

- Components labeled: D3825-041 END RIB ASSY, D3827-041 INBOARD RIB ASSY, D3825-041 END RIB ASSY, D2221-1 RIB, D2581 MOUNTING BRACKET 2 PL.
- Dimensions: 25.50, 30.00, 34.50, 30.00.
- Callouts: A2-3, F, E, A6-4, TYP, D B7-4.

**Cross-section View:**

- Components labeled: D2235-1 RIB, D3826-041 GUSSET RIB ASSY, D2221-5 RIB, D2221-7 RIB, D2221-5 RIB.
- Dimensions: 19.63, 56.00, 19.63 REF, 96.00±0.13.
- Callouts: A, B, C, A6-2, C2-2, C6-2, C8-2.

**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
02/11/18 NND

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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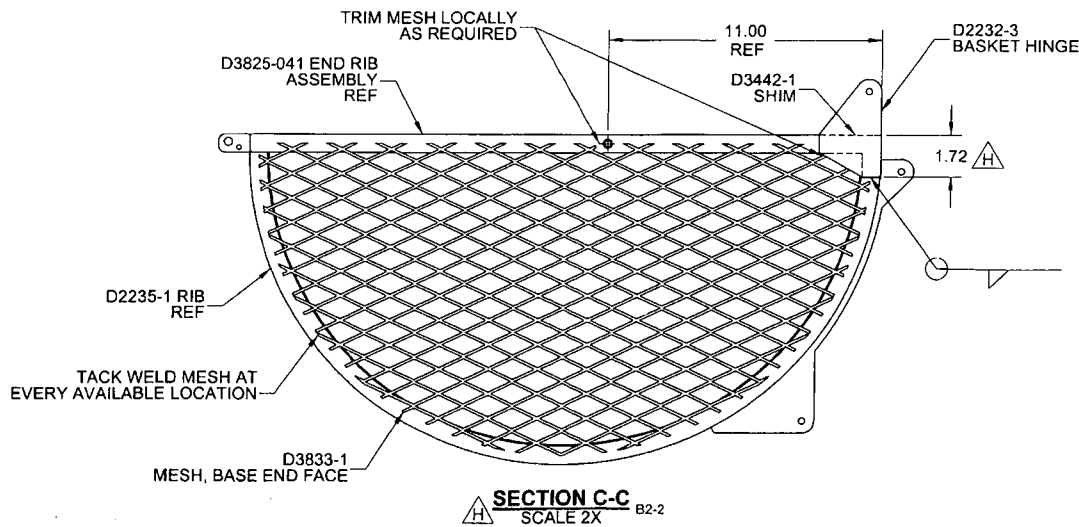
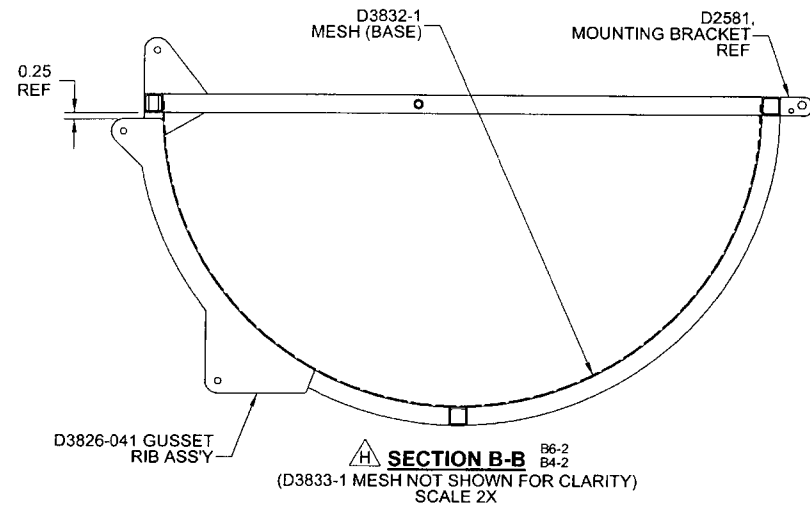
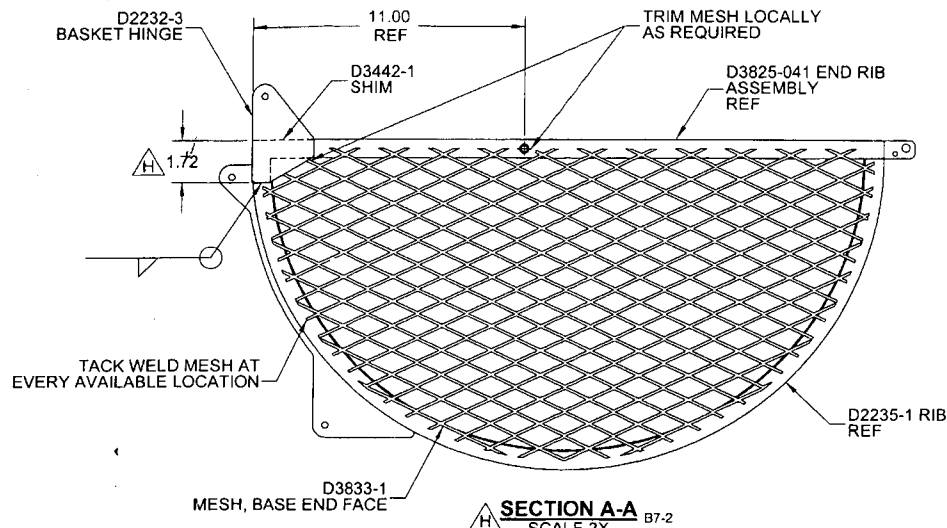
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81316



RELEASED

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	435	DRAWING NO. D2221	REV. H
MFG. APPR.	A	SHEET 3 OF 5	
APPROVED	11	SCALE	
DE APPR.	H	<b>BASKET BASE ASSEMBLY (350)</b> NTS	
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

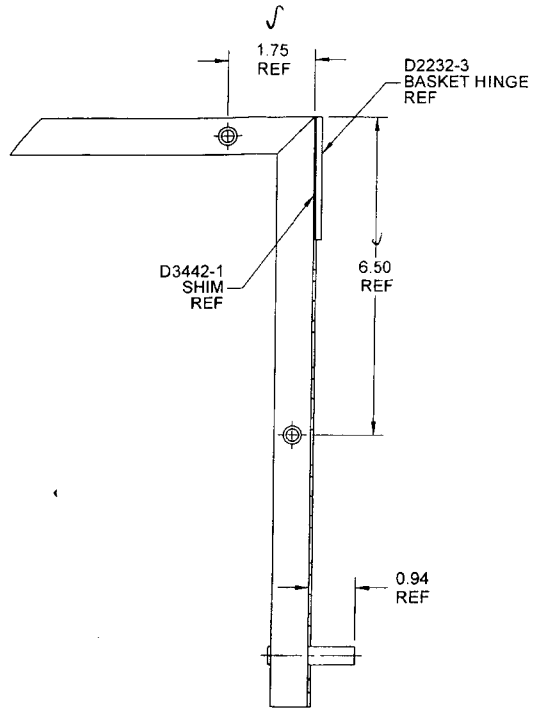
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

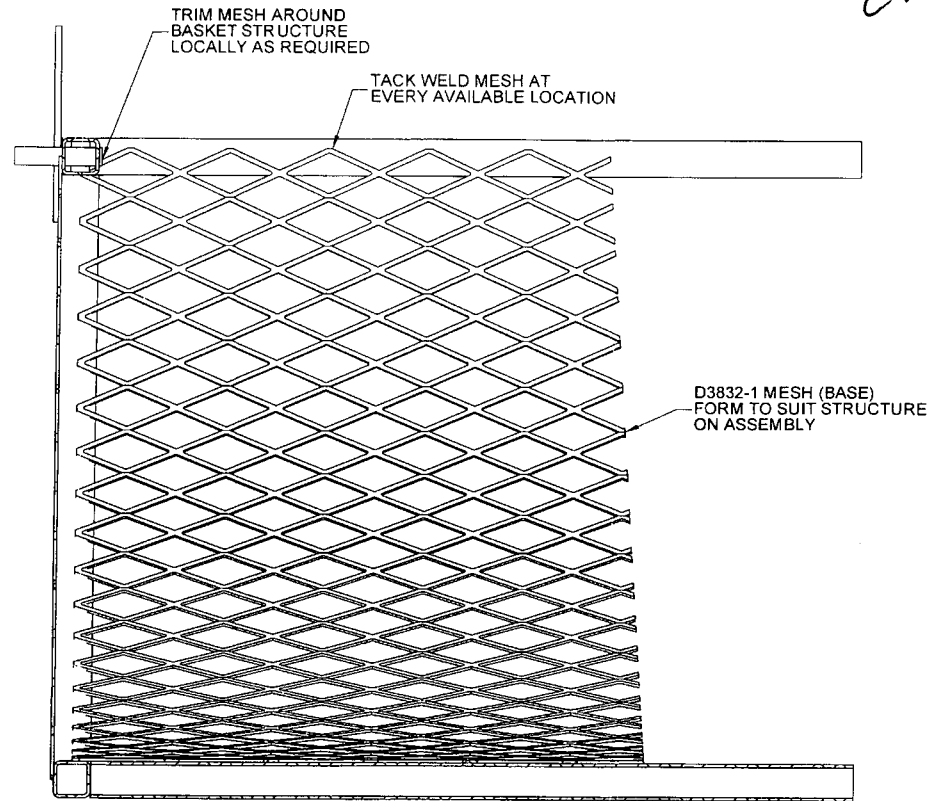
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

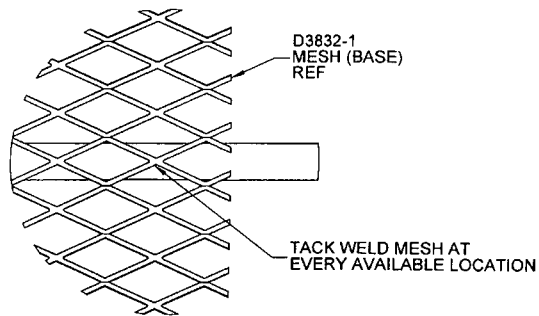
81316



**DETAIL D**  
SCALE 4X D2-2



**SECTION F-F**  
SCALE 4X D7-2



**DETAIL E**  
SCALE 4X C6-2

**RELEASED**  
08/11/16

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	148	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b>	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

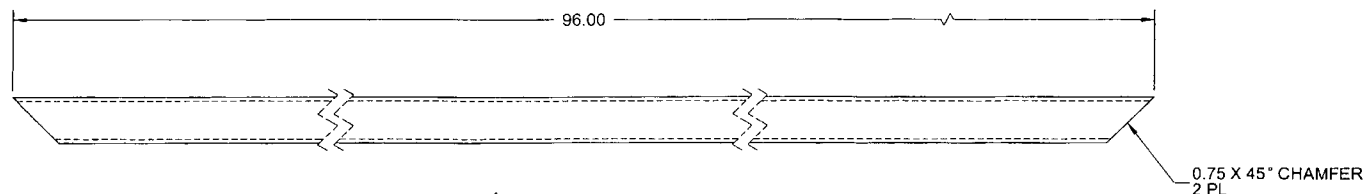
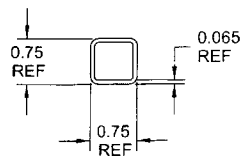
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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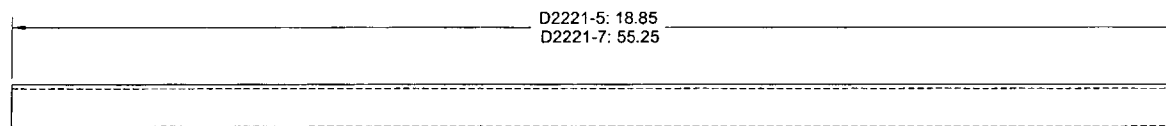
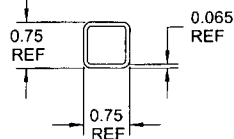
**NOTE:** Date & initial all entries



81316



**D2221-1 RIB**



**D2221-5/-7 RIB**

**RELEASED**  
08/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. I
MFG. APPR.	MO	D2221	SHEET 5 OF 5
APPROVED	MY	TITLE	SCALE
DE APPR.	JH	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
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**NOTE:** Date & initial all entries